













Date: Tuesday, 3/27/2007 8:18:51 AM
 User: Chantal Lavoie

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BUSHING
Job Number	: 31514		
Estimate Number	: 12686		
P.O. Number	: N/A	Part Number	: D35911
This Issue	: 3/27/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3591
First Issue	: N/A	Project Number	: N/A
Previous Run	: 30571	Drawing Revision	: A
		Material	: N/A
Written By	: 	Due Date	: 3/30/2007
Checked & Approved By	: _____	Qty:	40 Um: Each
Comment	: EST A 07.02.01 new issue EC		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0500W035	304 RD Tube .500 x .035W	
			
Comment: Qty.: 0.3675 f(s)/Unit Total: 14.7000 f(s) 304 RD Tube .500 x .035W Batch: M103453 J.F. 07/03/28			
2.0	LATHE CONV.	CONVENTIONAL LATHE	
			
Comment: CONVENTIONAL LATHE 1-Turn as per dwg D3591 2-Deburr J.F. 07/03/28 (43)			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE J.F. 07/03/28 (43)			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK J.F. 07.03.28 43			
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
			
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____ J.F. 07/03/28 (43)			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: PD Date: 07/03/29
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 31514

Part Number: D35911

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



43

Comment: FINAL INSPECTION/W/O RELEASE

07/03/29

Job Completion



W 07-03-29

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

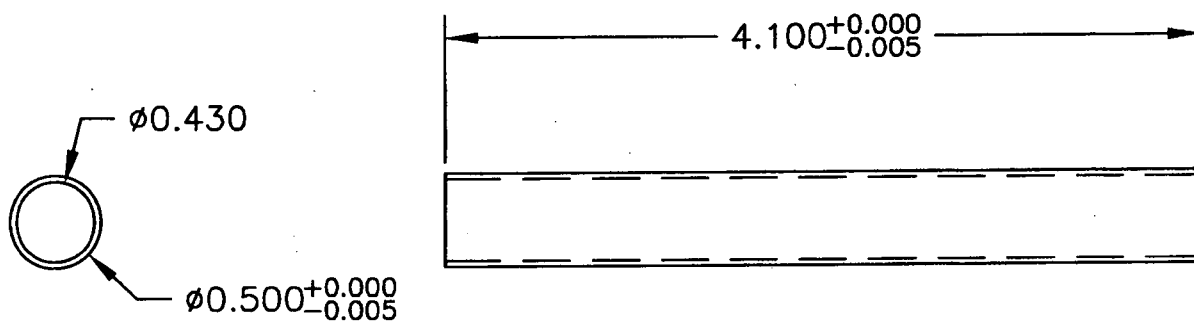
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED PH	DRAWING NO. D3591	REV. A SHEET 1 OF 1
DATE 07.01.16		TITLE BUSHING	SCALE 1:1
A	07.01.16	NEW ISSUE	

**D3591-1 BUSHING****RELEASED**07.01.30 **PH****D3591-1 BUSHING**

- 1) MATERIAL: AISI 304/316 SS, $\phi 0.500$, 0.035 WALL SEAMLESS ROUND TUBING
(REF. DART SPEC M304TR0.500W.035)
- 2) FINISH: NONE
- 3) BREAK ALL UNMARKED SHARP EDGES TO 0.010 MAX
- 4) ALL DIMENSIONS ARE INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O 31514
C207/03/27

DART AEROSPACE LTD		Work Order: 31514
Description: Crosstube Assembly		Part Number: 03591-1
Inspection Dwg:	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	4.100"	+0.000 -0.005	4.095"	✓		
	Ø .500"	+0.000 -0.005	Ø .500"	✓		
	Ø .430"	+0.010"	Ø .435"	✓		
SIDE B						

Measured by: J.F.	Audited by:	Prototype Approval:	N/A
Date: 07/03/28	Date:	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	